

**Amendments to the Specification:**

Please insert the following Abstract paragraph:

W A computer controlled grinding machine grinds a cylindrical region and an annular shoulder of a rotatable workpiece. Relative movement is effected between the workpiece and a grinding wheel along a line of action which subtends an angle of approach of less than 90 degrees to the Z axis of rotation of the workpiece. Such an angle of approach enables the wheel to grind the annular shoulder of the workpiece simultaneously with grinding the cylindrical portion.

Enclosed is a separate sheet containing the above Abstract.

Please replace the title of this application with the following:

**Angle Head Grinding Apparatus**